

Work Order ID 91117-2 *SPLIT*

October-03-12 8:55:31 AM

\*91117\*

Page 1

Item ID: D3413-1

Revision ID:

Item Name: Ring

Start Date: 02/10/2012 Start Qty: 160.00

Required Date: 13/11/2012 Req'd Qty: 160.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

\*160\*

\*160\*

Approvals:

Process Plan: *MLJ*

Date: 12-10-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3413

Rev A

100

\*100\*

Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3413

Dwg Rev: *A*

Prog Rev: *A*

2- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1

23

137

*Jm 12-10-1*

*Jm 12-12-5*

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

23

137

*Jm 12-10-14*

*Jm 12-12-5*



# Work Order ID 91117

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\*91117\*

Page 2

Item ID: D3413-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Ring

Start Date: 02/10/2012 Start Qty: 160.00

\*160\*

Cust Item ID:

Required Date: 13/11/2012 Req'd Qty: 160.00

\*160\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*150\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Memo

0.00

Quality Control

TRN

TRN

TRN

TRN

TRN

TRN

TRN

TRN

TRN

TRN

TRN

TRN





# Work Order ID 91117

October-03-12 8:55:31 AM

\*91117\*

Page 3

Item ID: D3413-1

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Ring

Start Date: 02/10/2012 Start Qty: 160.00

\*160\*

Cust Item ID:

Required Date: 13/11/2012 Req'd Qty: 160.00

\*160\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: *ST 464* 0.00

\*170\*

Packaging

Memo

0.00

Packaging

*B7X*

*SP*  
*12/12/19*

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

*12/12/2012*

*12-20-12*



# Picklist Print

October-03-12 8:55:34 AM

Page 1

Work Order ID: 91117

\*91117\*

Parent Item: D3413-1

\*D3413-1\*

Parent Item Name: Ring

Start Date: 02/10/2012

Required Date: 13/11/2012

Start Qty: 160.00

Required Qty: 160.00

## Comments:

IPP Rev:A05.09.13New issueKJ/JLM

IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.250X4.000

Purchased

No

100

f

26.0500

0.25

~~42.10526~~

\*\*

42.5

\*M304B0 250X4 000\*

304 BAR 250 x 4.00

Jm 12-10-

Jm 12-12-5

## Location

## Loc Qty

## Loc Code

MAT050

26.05

119043

14.3

119766

3.25

119840

8.5

119840 x 23 = 6.1 S.F.

123649

123649 x 137 = 36.4 S.F







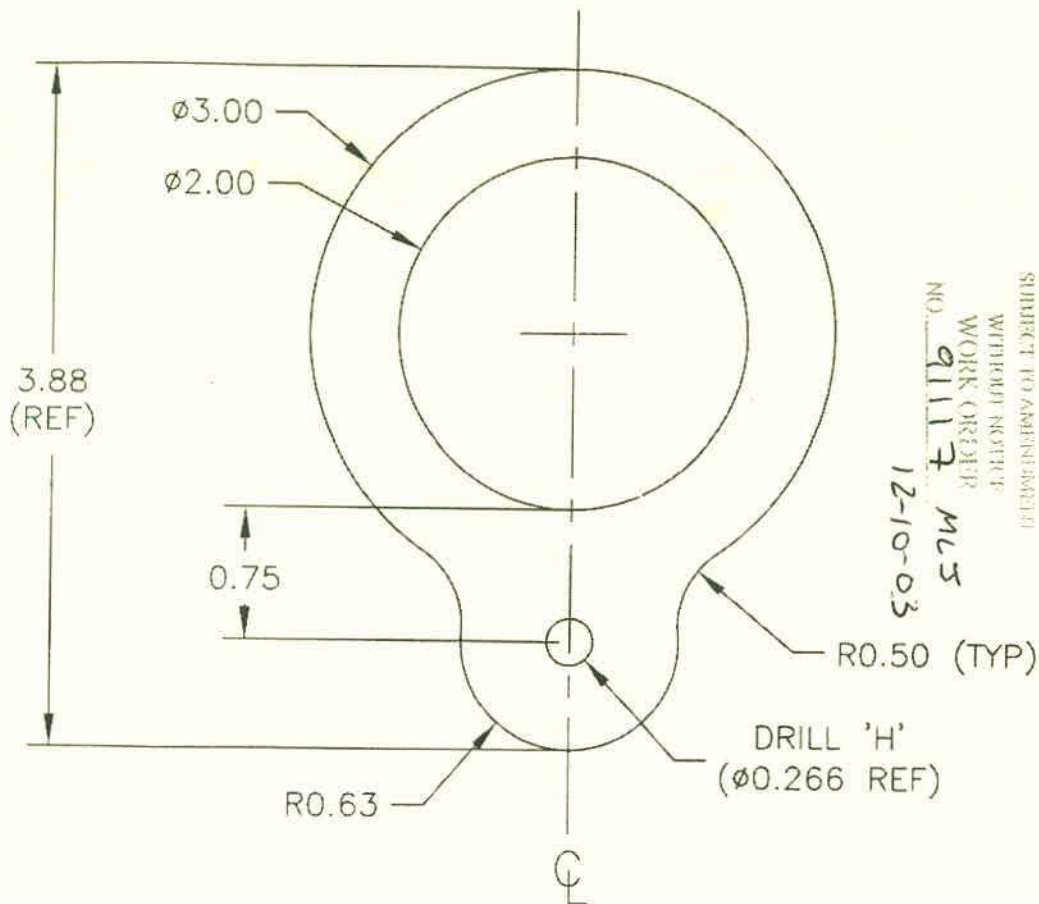


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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED  
05-09-06 *[Signature]*

**D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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